

Date: Tuesday, 11/22/2005 9:50:22 AM  
 User: Linda Lacelle

## Process Sheet

Cust : CU-DAR001 Dart Helicopters Services Drawing Name : NUT PLATE ASSEMBLY  
 Job Number : 24895B  
 Estimate Number : 10812  
 P.O. Number : N/A Part Number : D3178041  
 This Date : 11/22/2005 S.O. No. : N/A Drawing Number : D3178 REV. A  
 Prsh : NC Project Number : N/A  
 First Date : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 22409B Material : N/A  
 Due Date : 12/15/2005 Qty: 4 Um: Each  
 Written By : See comment below  
 Checked & Approved By : See comment below  
 Comment : Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF

## Additional Product

Job Number:



Machine Or Operation: Description :

1.0 M5052H32S063 5052-H32 .063 Sheet



Comment: Qty.: 0.0365 sf(s)/Unit Total : 0.1462 sf(s)

Material: 5052-H32/H34 (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: M16454

J.G 05/12/09 24

2.0 SHEAR

SHEAR



M5052H32S063



Comment: SHEAR

Cut blanks: 3.00" x 1.520"

.88

J.G 05/12/09 24

3.0 HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA296 and Dwg D31

Identify as D3178-1

J.G 05/12/09 24

4.0 QC2



HINE



Comment: INSPECT PARTS AS THEY COME OFF M.

J.G 05/12/09 24

5.0 QC8



Comment: SECOND CHECK

SA 05.12.09 24

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Customer: CUDAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Number: 24095B

Part Number: D3178041

Job Number:



Step #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- C'sink D3178-1 holes as per Dwg D3178  
2- Deburr

FF

05-12-12

24

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05-12-13

24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

FF

05-12-14

24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

05-12-14

24

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)  
RIVET

Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-4	Rivet	M15786

FF

05-12-19

24

11.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Nut Plate

Pick:

Qty	Part Number	Description	Batch
	MS21059L3	Nut Plate	M14602

FF

05-12-19

24

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3178

FF

05-12-19

24

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## Process Sheet

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 24895B

Part Number: D3178041

Job Number:



Step:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



*25-12-19*

Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *402*

*6/12/19 (24)*

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*05/12/20 (24)*

Job Completion



*u*



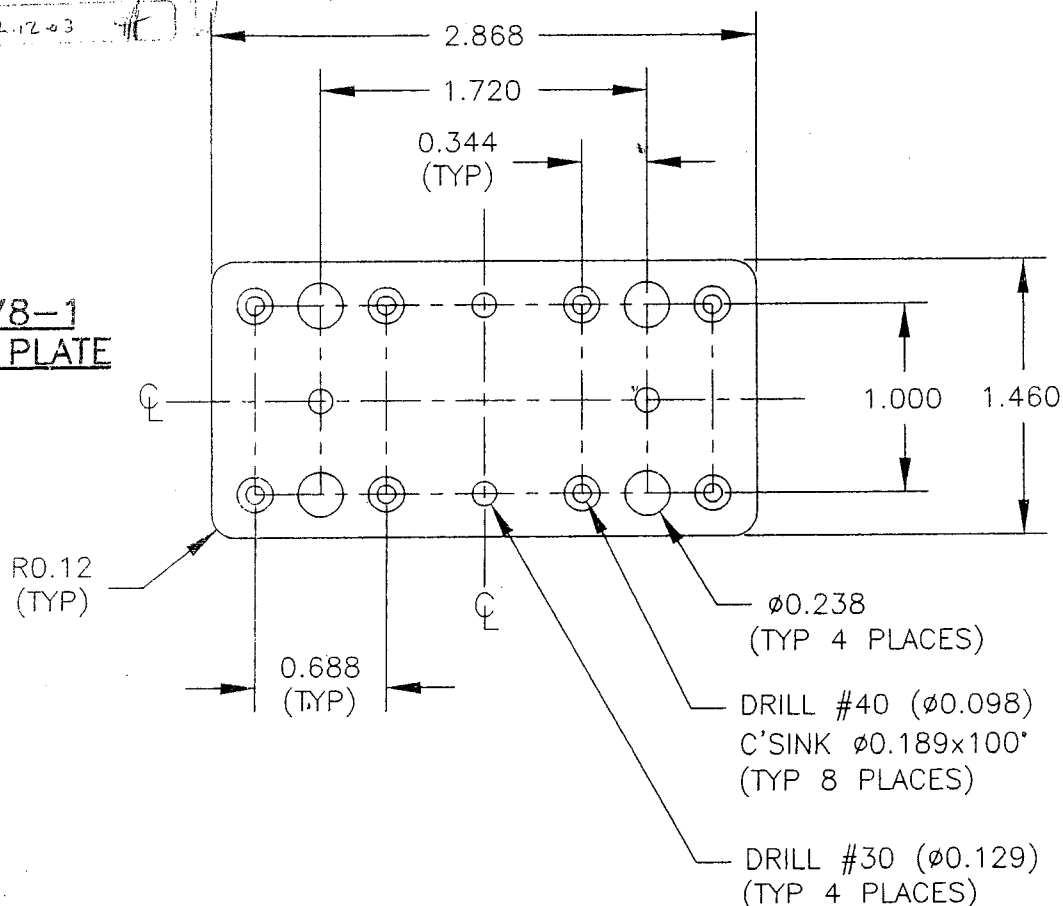
CONTROLLED COPY



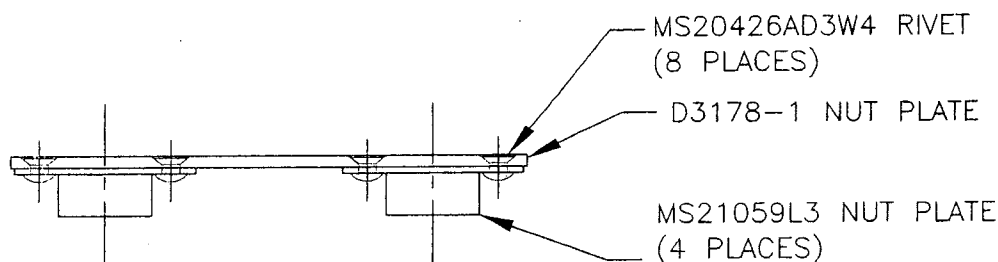
DESIGN <i>ip</i>	DRAWN BY <i>ip</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

RELEASED  
02.12.03

### D3178-1 NUT PLATE



### D3178-041 NUT PLATE



#### NOTES, D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)  
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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